

Work Order ID 65484

Tuesday, January 18, 2011 2:35:54 PM



Page 1

Item ID: D4055-041

Accept



Setup Start



Revision ID:

Item Name: Fuel Tank Assembly

Stop



Start Date: 1/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-01-18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

A

Ph =>

100

Weld per dwg A/R Aluminum rod Batch: M108436

M115928

0.00

Large Fab

Memo

Large Fab

1- weld D4023-1 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

11.03.01 1

W/O: 65484		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/03/09	#100	Rev. change ADD Part Routing numbers to W/O to clarify where parts Are to be picked.	<i>[Signature]</i>	11.03.16			<i>[Signature]</i> 11/03/09	

Part No: D4055-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE11/03/07

121

Weld per dwg A/R Aluminum rod Batch: M102436

0.00



Large Fab

Memo

0.00

Large Fab

1-Weld top D4055-1

11-03-07

1 0

Plb →

122

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE11/03/09

W/O: 65484		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/03/09	# 121/124	Perm. Change Put pressure test to 4.01bs @ 15 mins as a step before ac 9.		11.03.16			S 11/03/09	
	ie	(Should be as this #121 - weld 122 - pressure test @ 4.01bs @ 15 min 123 - ac 9 124 ac 5 ent.)						

Part No: D4055-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Revision ID:					Stop	
Item Name:	Fuel Tank Assembly					
Start Date:	1/18/2011	Start Qty:	1.00	Cust Item ID:		
Required Date:	2/16/2011	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***Pressure Test as per dwg*** pressure tested to 4 PSI for 30 min 11/03/09	0.00 0.00		84103109	(K)				
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo 1- brush alodine on tank. No alodine inside	0.00 0.00							
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

1 BL 11-3-11
1 p 11/03/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Pressure Wash per OSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing	Pressure test as per dwg								
160 	Chemical Conversion Coat per OSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
170 	Grey Sandtex(Ref:4.3,5.6) per OSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	***Mask prior to powdercoat*** Start Time: 11:40 Oven Temperature: 300° Finish Time: 12:00								

Handwritten notes:
A/AS
Remover

Handwritten notes:
1 12 11-3-11

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 of 11/03/11

190

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

E 34/03/16 (11)

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W 11 03 16 (11)

W/O:		WORK ORDER CHANGES					
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Required Date: 2/16/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 SprayPaint Spray Painting	<i>Memo</i> Seal inside of tank using Sloshing Sealer as per dwg	0.00 0.00				1	4	11/03/15	
220 QC Quality Control	QC5- Inspect part completeness to step on W/O <i>Memo</i>	0.00 0.00				11	03	16	1
230 Packaging Packaging	Identify as per dwg & Stock Location: _____ <i>Memo</i> PAP 66725	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/16 JF

MF
11-03-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 65484

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly



Start Date: 1/18/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B
10.05.17 ECN10-562 DD verf:EC IPP Rev C: 10.11.23
revised pick list EC verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1 Placard		Manufactured	No				Each	6.0000		1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST108				6					
					55400			6		58400			
D3997-5 Placard		Manufactured	No				Each	3.0000		2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST108				3					
					55402			3		65436			
D3997-11 Placard		Manufactured	No				Each	15.0000		1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST108				15					
					55407			5		55407			
					65124			10					
D3997-17 Placard		Manufactured	No				Each	15.0000		1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST108				15					
					55410			5		55410			
					65125			10					

W/O:		WORK ORDER CHANGES					
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Work Order ID: 65484



Parent Item: D4055-041



Parent Item Name: Fuel Tank Assembly

Start Date: 1/18/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

D3997-29 Manufactured No

Each 15.0000

1



Placard



Location

Loc Qty

Loc Code

ST108

15

55416

5

65126

10

55416

1

D3997-43 Manufactured No

Each 15.0000



Placard



Location

Loc Qty

Loc Code

ST108

15

55422

5

65127

10

55422

1

✓ D3999-7 Manufactured No

Each 7.0000



Corner



Location

Loc Qty

Loc Code

ENG

5

55645

5

ST110

2

59478

2

1

1

1

✗ D3999-9 Manufactured No

Each 6.0000



Angle



Location

Loc Qty

Loc Code

ENG

5

55646

5

ST

1

59479

1

1

1

1

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Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 65484

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/18/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

D3999-11

Manufactured No

Each

6.0000



Earth Tab



1

11.03.07

Location

Loc Qty

Loc Code

ENG

5

55863

5

1

ST

1

59477

1

D3999-041

Manufactured No

Each

1.0000



Baffle Assembly, Aft



1

11.02.18

Location

Loc Qty

Loc Code

ST137

365437

1

1

59473

1

D3999-043

Manufactured No

Each

1.0000



Baffle Assembly, Fwd



1

11.02.18

Location

Loc Qty

Loc Code

ST137

365439

1

1

59476

1

D4000-1

Manufactured No

Each

5.0000



Fuel Supply Fitting



1

11.03.08

Location

Loc Qty

Loc Code

ENG

55867 one left ² ₍₂₎

3

1

ST

3

59698

3

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W/O:		WORK ORDER CHANGES					
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Start Date: 1/18/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4000-5



Fuel Tank Vent Fitting

Manufactured No

Each 3.0000

1

11.02.19

Location

Loc Qty

Loc Code

ENG

3

55869

1

59699

2

Each 14.0000

3

11.02.19

✓ D4000-9



Grommet

Manufactured No

Location

Loc Qty

Loc Code

ST105

13

65109

13

ST114

1

59486

1

Each 0.0000

1

11.02.19 365036

✓ D4000-043



Drain Fitting Assembly, Fwd

Manufactured No

Each 0.0000

1

11.03.07 367063

✓ D4000-045



Fuel Pickup Fitting Assembly

Manufactured No

Each 0.0000

1

11.02.19 365038

✓ D4000-041



Drain Fitting Assembly, Aft

Manufactured No

Each 3.0000

1

11.02.19

✓ D4001-1



Fitting

Manufactured No

Location

Loc Qty

Loc Code

ENG

3

59487

3

1

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Start Date: 1/18/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

* D4008-11
Hinge Half

Manufactured No

Each 2.0000

1

Location

Loc Qty

Loc Code

N/A

2

59490

2

D4008-041
Fuel Filler Splash Guard Assembly

Manufactured No

Each 5.0000

1

Location

Loc Qty

Loc Code

ST112

5

55875

2

59489

1

59517

2

✓ D4023-1
Cap and Flange

Manufactured No

Each 0.0000

1

✗ D4025-1
Fuel Quantity Sender

Manufactured No

Each 2.0000

1

Location

Loc Qty

Loc Code

ST116

2

62139

2

✓ D4055-11
Tank Front and Bottom

Manufactured No

Each 2.0000

1

Location

Loc Qty

Loc Code

WA

2

63944

2

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Start Qty: 1.00

Required Qty: 1.00

✓ D4055-9	Manufactured	No	Each	3.0000	1		<i>11.02.18</i>
							
Tank Back							
<hr/>							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		WA		3			
		63948		3			
✓ D4055-7	Manufactured	No	Each	3.0000	1		<i>11.02.19</i>
							
Tank Fwd End							
<hr/>							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		WA		3			
		64032		3			
✓ D4055-5	Manufactured	No	Each	3.0000	1		<i>11.02.19</i>
							
Tank Upper Cut Out							
<hr/>							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		WA		3			
		63946		3			
✓ D4055-3	Manufactured	No	Each	2.0000	1		<i>11.02.19</i>
							
Tank Aft End							
<hr/>							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		WA		2			
		64030		2			
✓ D4055-1	Manufactured	No	Each	3.0000	1		<i>11.02.19</i>
							
Tank Top							
<hr/>							
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
		ST139A		3			
		64031		3			

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Start Date: 1/18/2011

Required Date: 2/16/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4057-1

Manufactured No

Each

30.0000

3



Retaining Ring



11.02.19

Location

Loc Qty

Loc Code

ST124

30

55826

30

AN3H5A

Purchased

No

Each

15.0000

3

5



Bolt



Location

Loc Qty

Loc Code

ST350

15

114941

15

NAS1149D0363J

Purchased

No

Each

3,268.000

114941

5



Washer



Location

Loc Qty

Loc Code

ST298

3268

115107

52

115622

16

116007

400

116025

200

116583

2600

116583

Tuesday, January 18, 2011 2:35:50 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

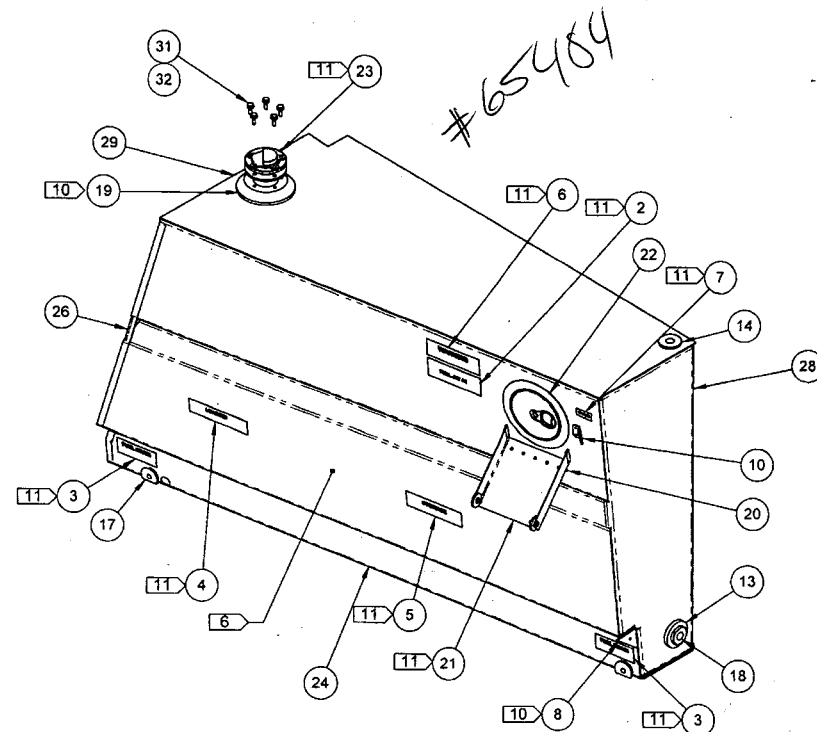
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3999-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041 - 65437	BAFFLE ASSEMBLY, AFT
12	1	D3999-043 - 65439	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-043	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-045	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-047	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-1	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-11	TANK FRONT AND BOTTOM
25	1	D4055-9	TANK BACK
26	1	D4055-7	TANK FORWARD END
27	1	D4055-5	TANK UPPER CUT OUT
28	1	D4055-3	TANK AFT END
29	1	D4055-1	TANK TOP
30	3	D4057-1	RETAINING RING
31	5	AN3H5A	BOLT
32	5	NAS1149D0363J	WASHER



D4055-041 AUX TANK

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS.
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT

RELEASED
2010-05-05
AM

A	NEW ISSUE		10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4055	REV. A
TITLE TANK	SHEET 1 OF 15
SCALE NTS	
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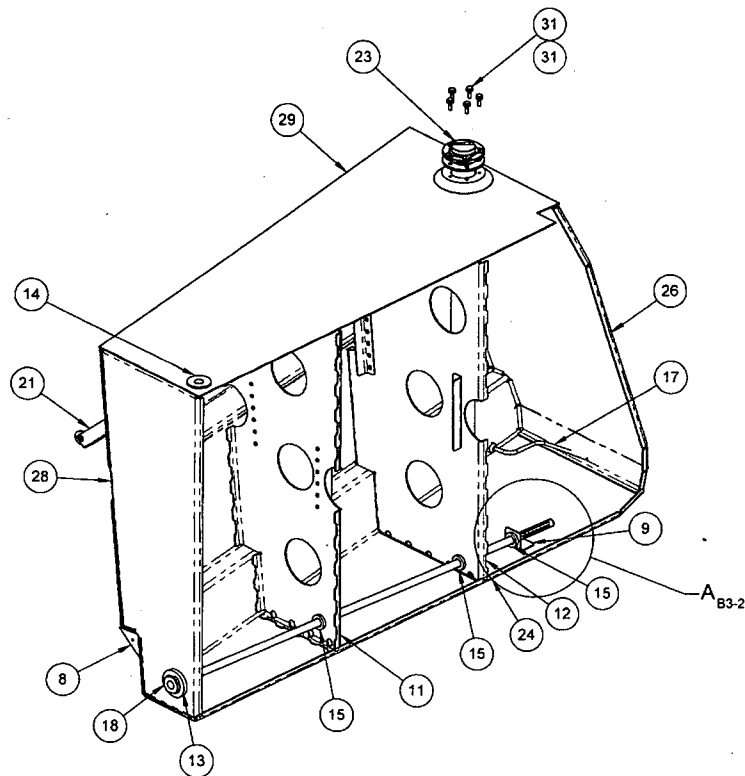
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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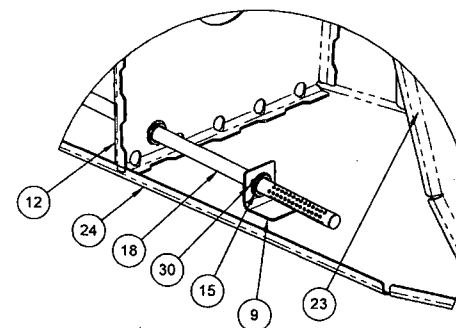
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries









D4055-041 AUX TANK
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A B3-2
ROTATED FOR CLARITY
SCALE: 2X

#65484

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2010-05-05
JMI

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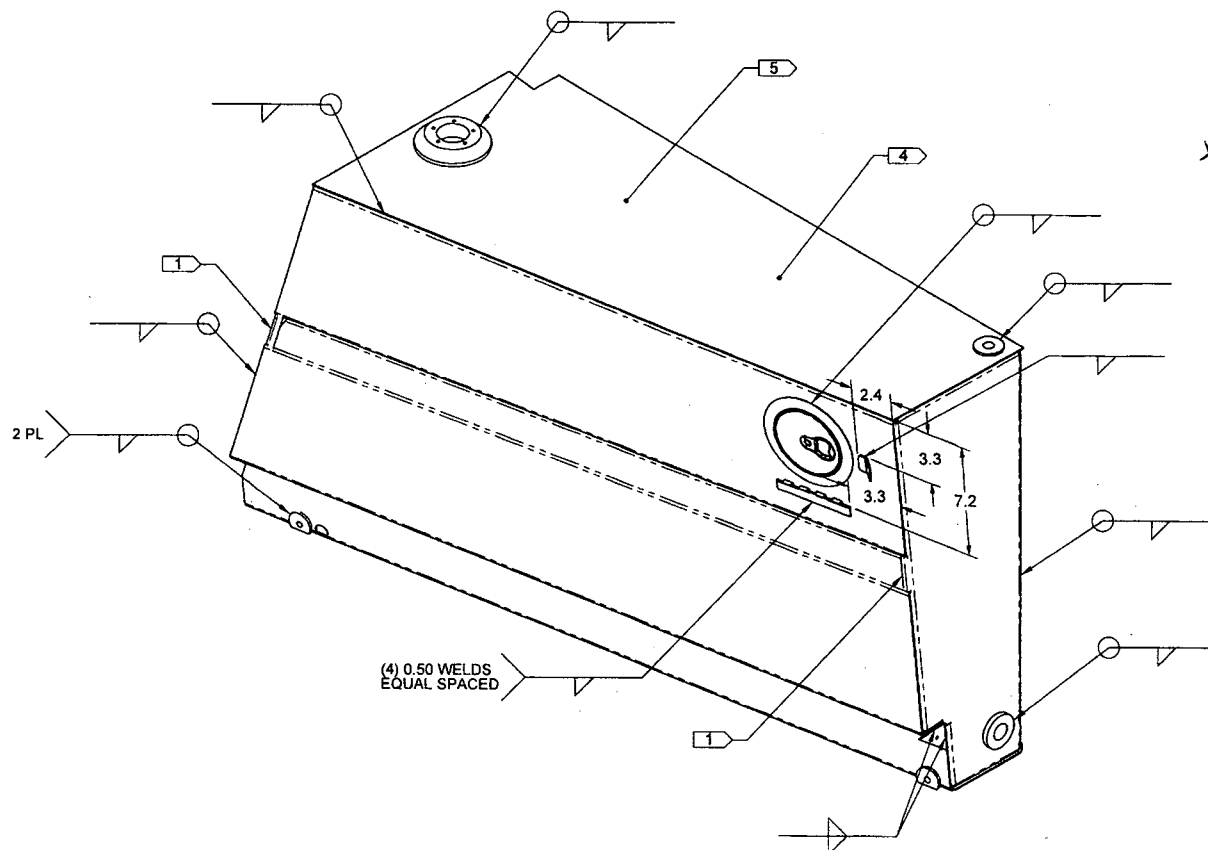
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-041 AUX TANK
WELDING DETAIL

RELEASED
2010-05-05
ND

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED:
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH FUEL TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH) SLOSHING SEALER. ENSURE FILTERS, FITTINGS AND SENDER UNITS ARE REMOVED AFTER WELDING
- 4) ACCEPTABLE TO DRILL 6 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)

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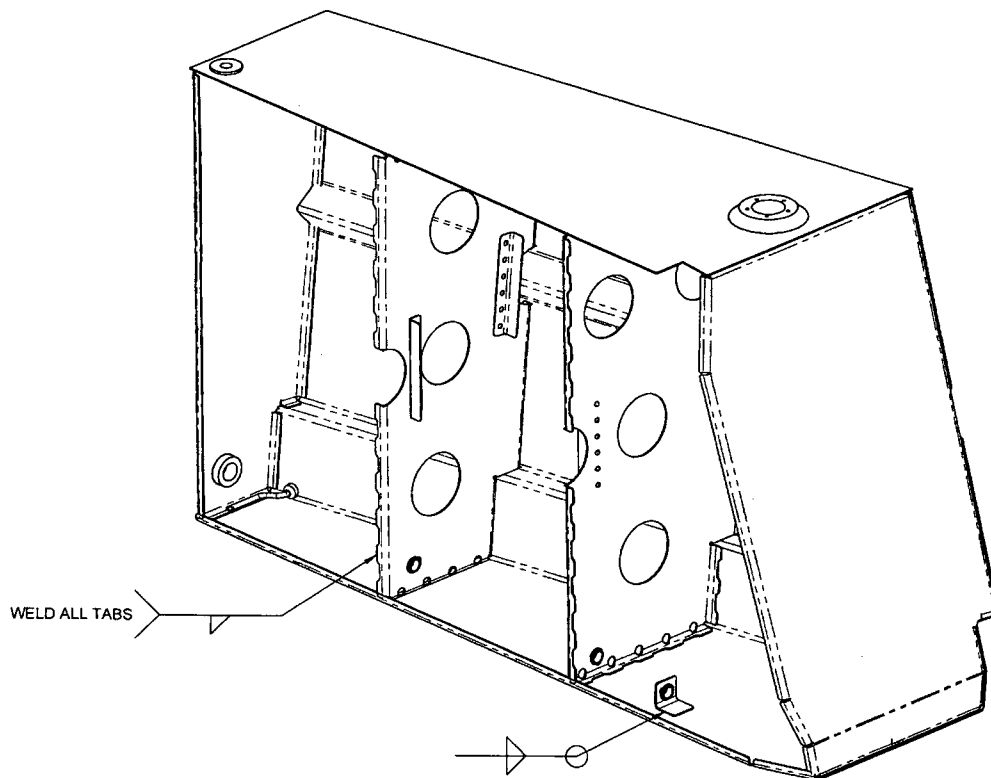
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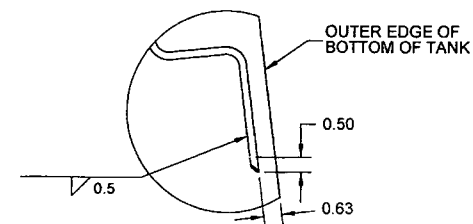
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries

#65484



D4055-041 AUX TANK
WELDING DETAIL



DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE

RELEASED
2010-05-05

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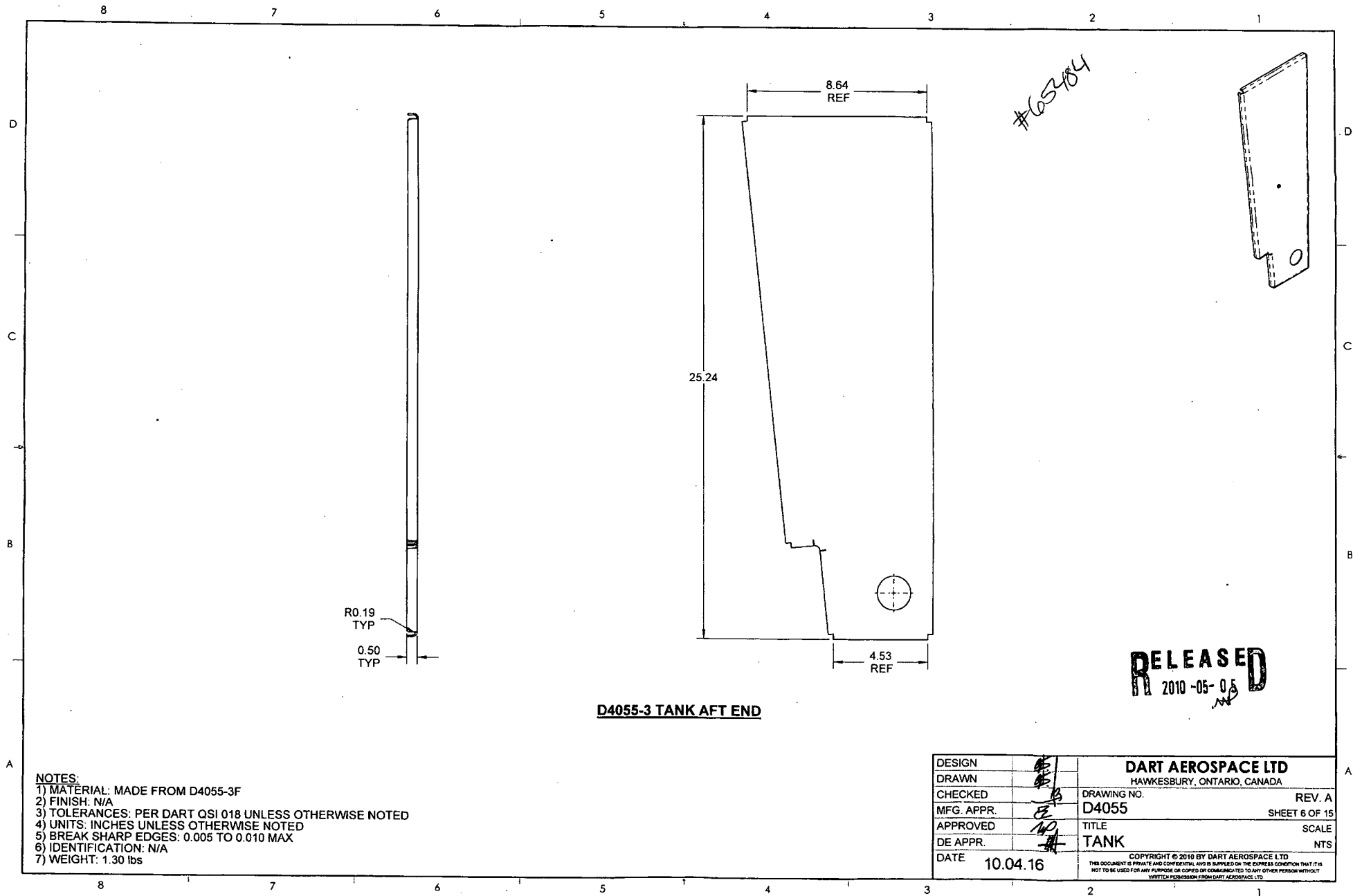
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries



NOTES:

- 1) MATERIAL: MADE FROM D4055-3F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

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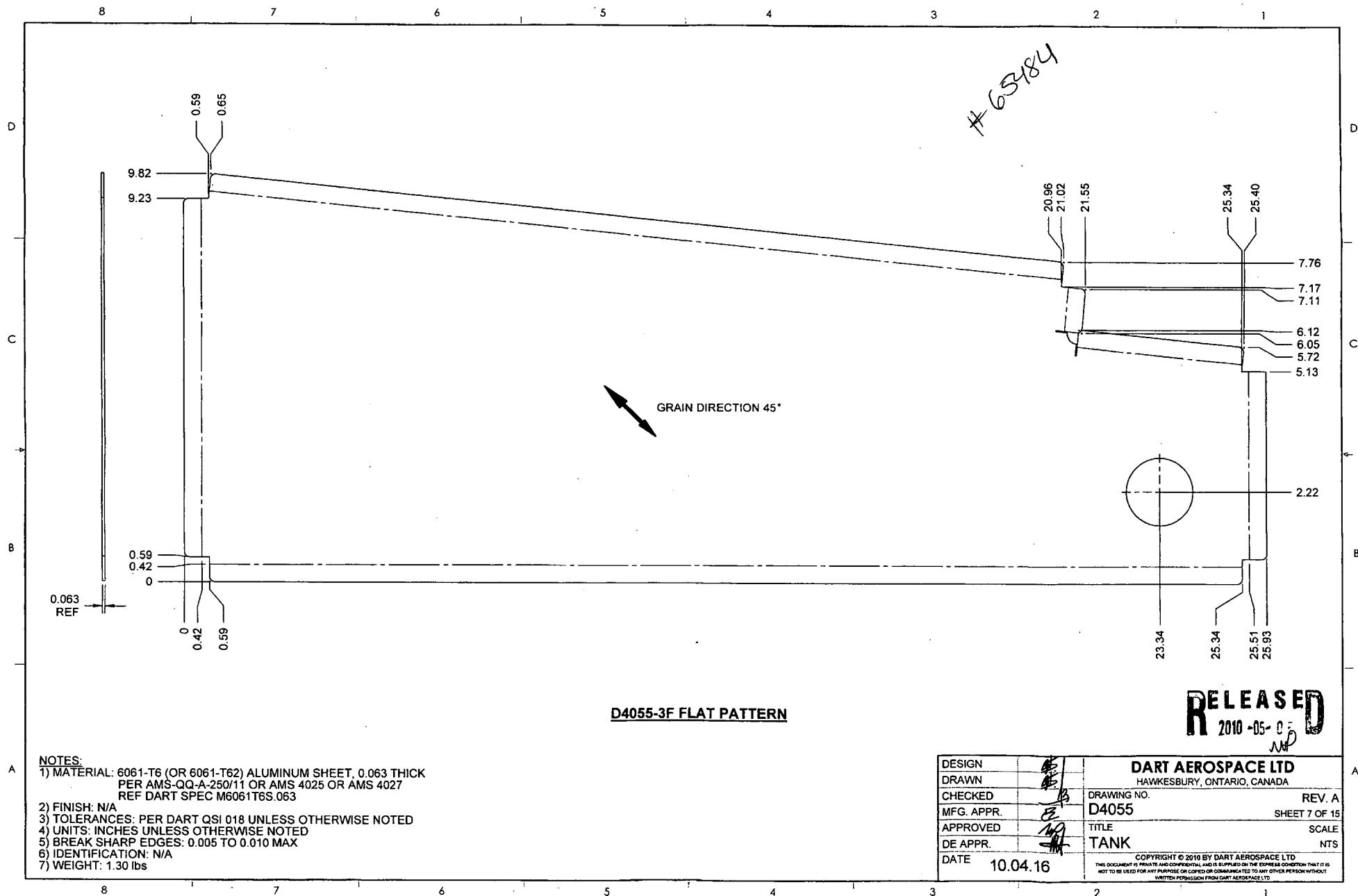
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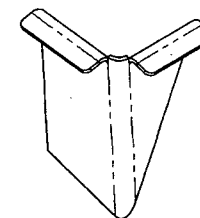
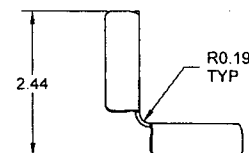
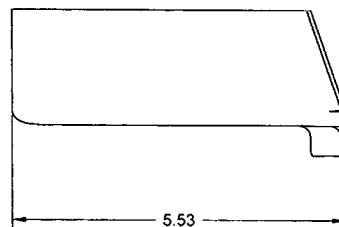
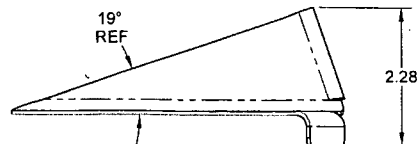
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries



#65484

D4055-5 UPPER CUT OUT

RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

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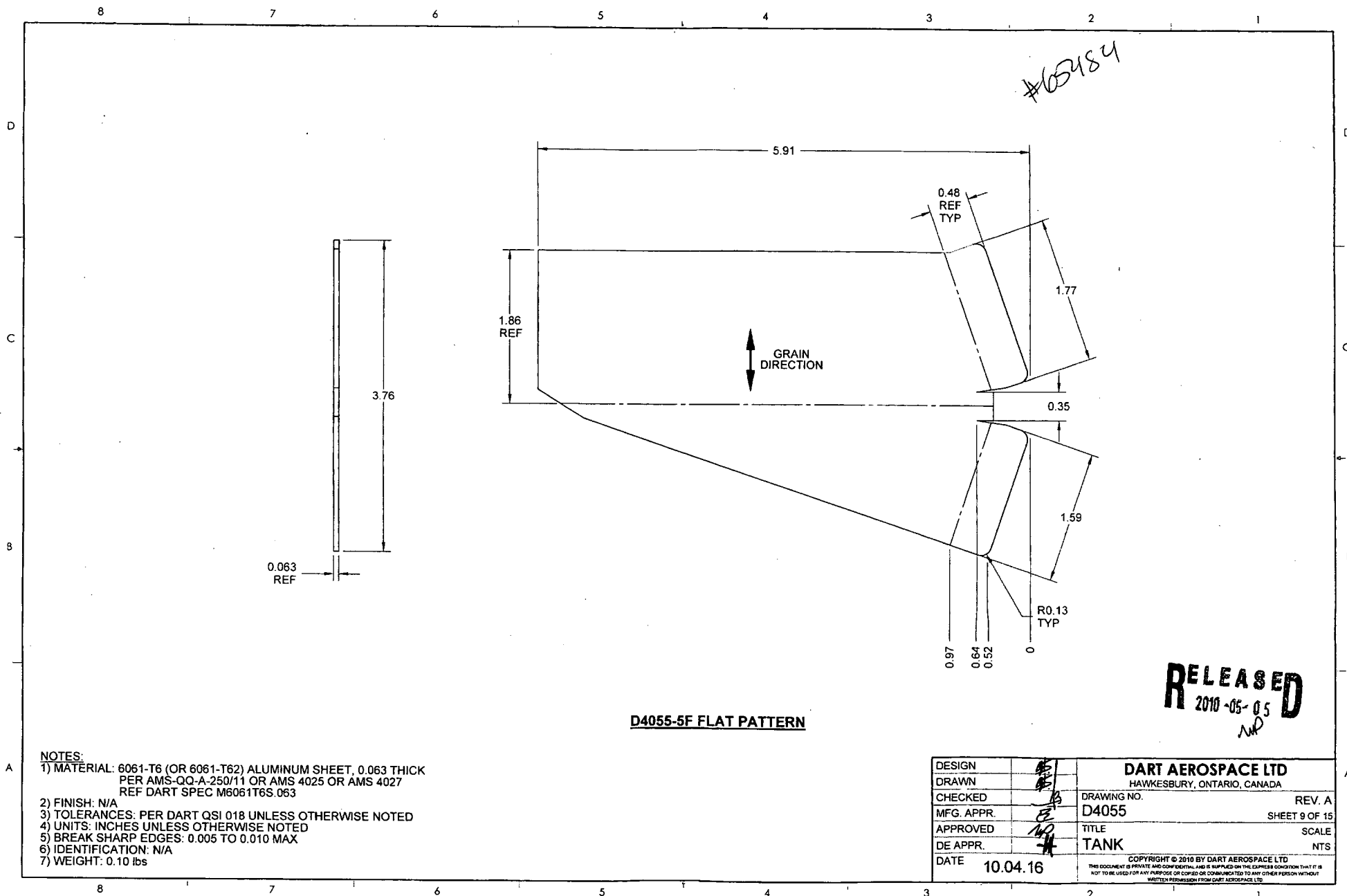
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____







NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries



D4055-5F FLAT PATTERN

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.10 lbs

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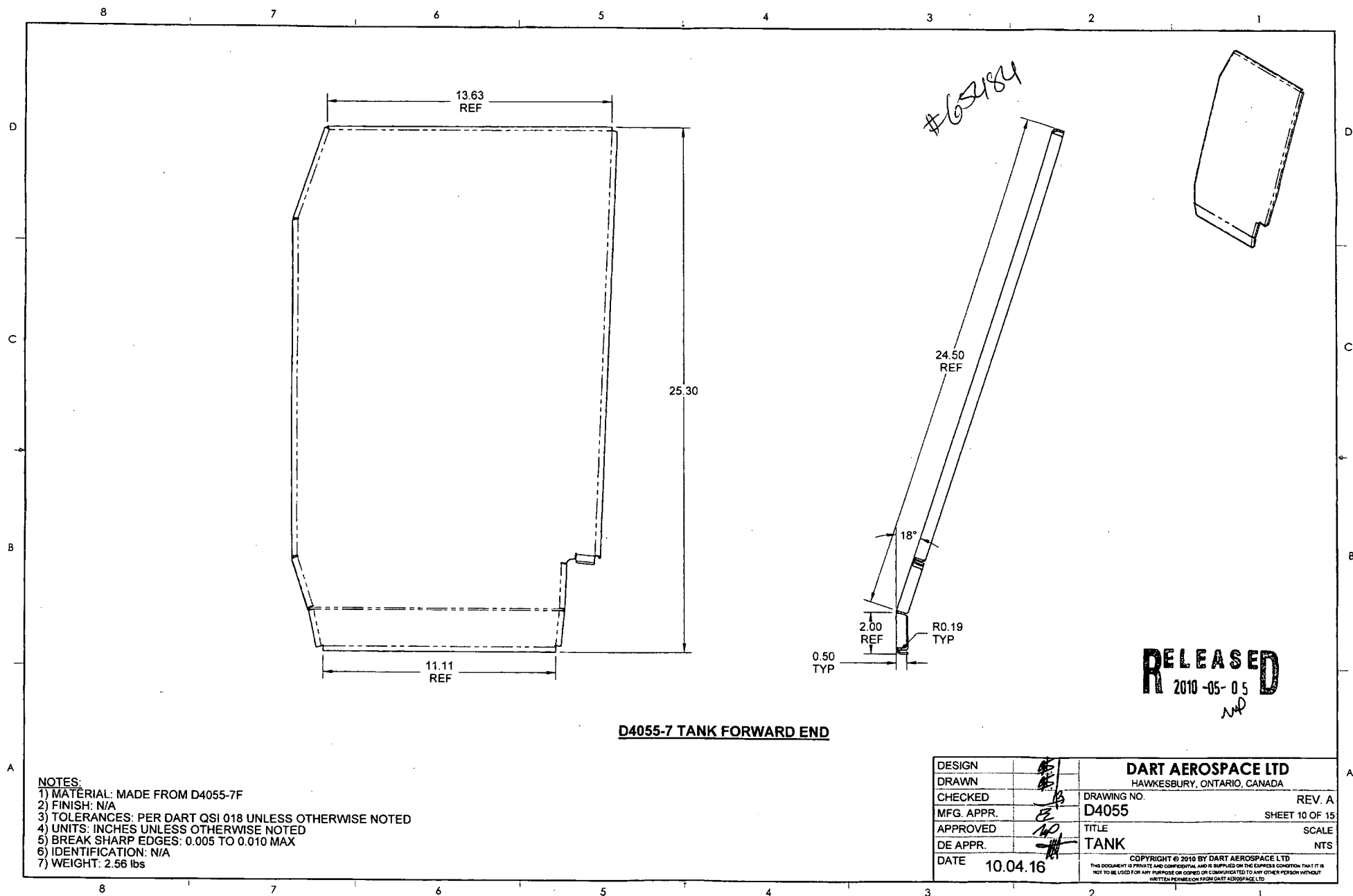
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries



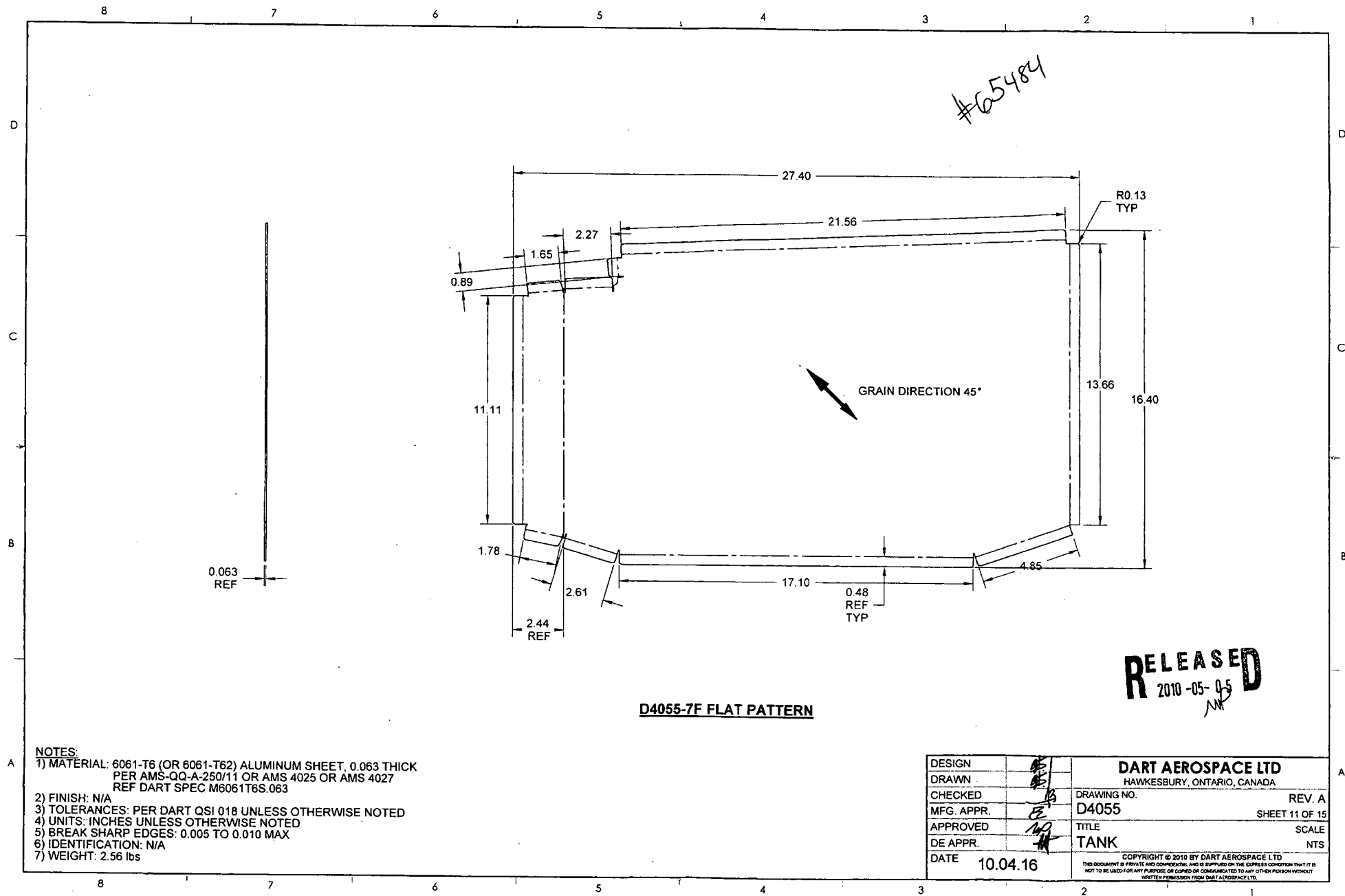
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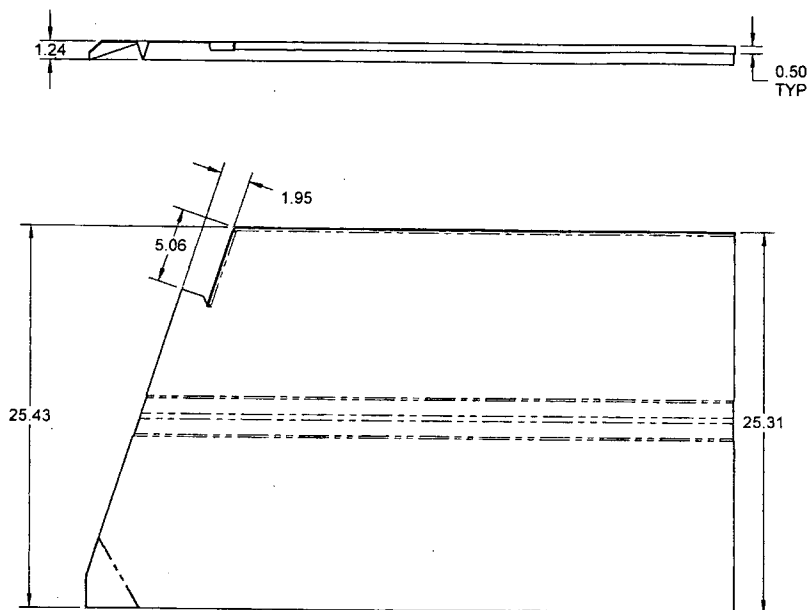
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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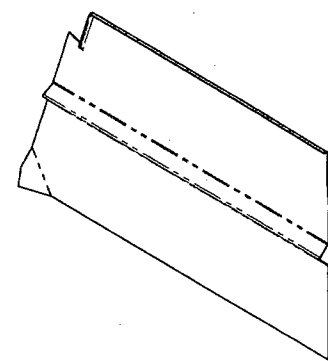
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries



#65484



D4055-9 TANK BACK

RELEASED
2010-05-05
MJD

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.41 lbs

DESIGN		DART AEROSPACE LTD	
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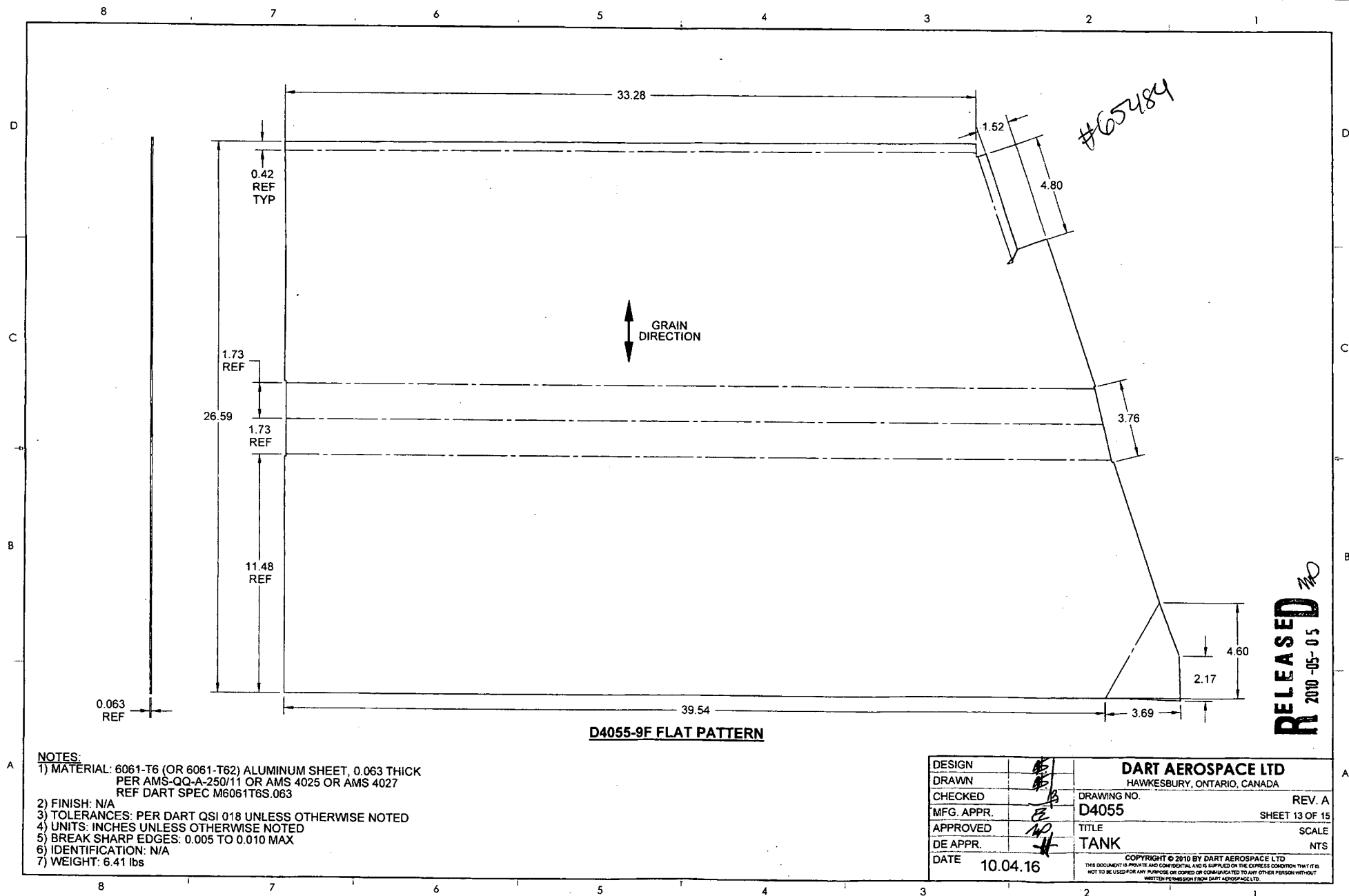
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2010-05-05

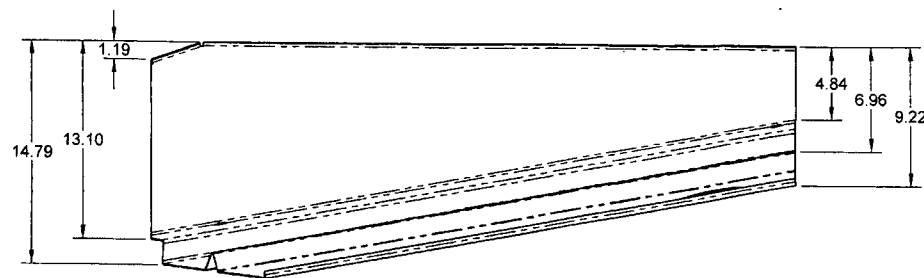
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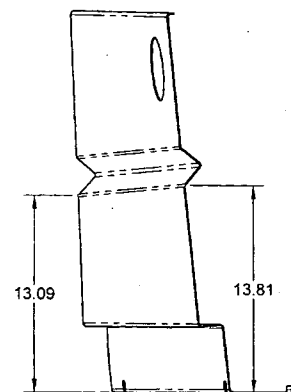
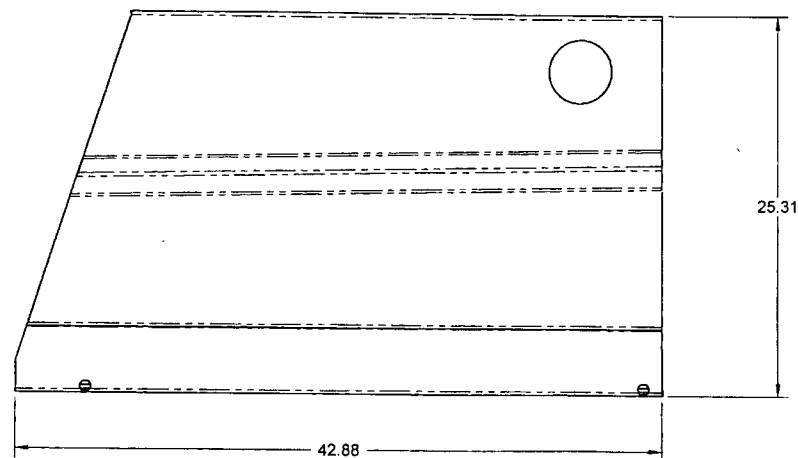
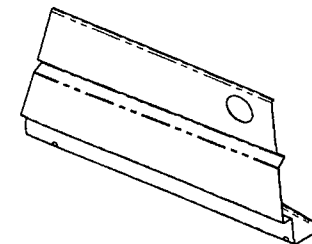
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries



#65484



D4055-11 TANK FRONT AND BOTTOM

RELEASED
2010-05-05
JMP

NOTES:

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.29 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4055 REV. A
MFG. APPR.		SHEET 14 OF 15
APPROVED		TITLE TANK SCALE
DE APPR.		NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD
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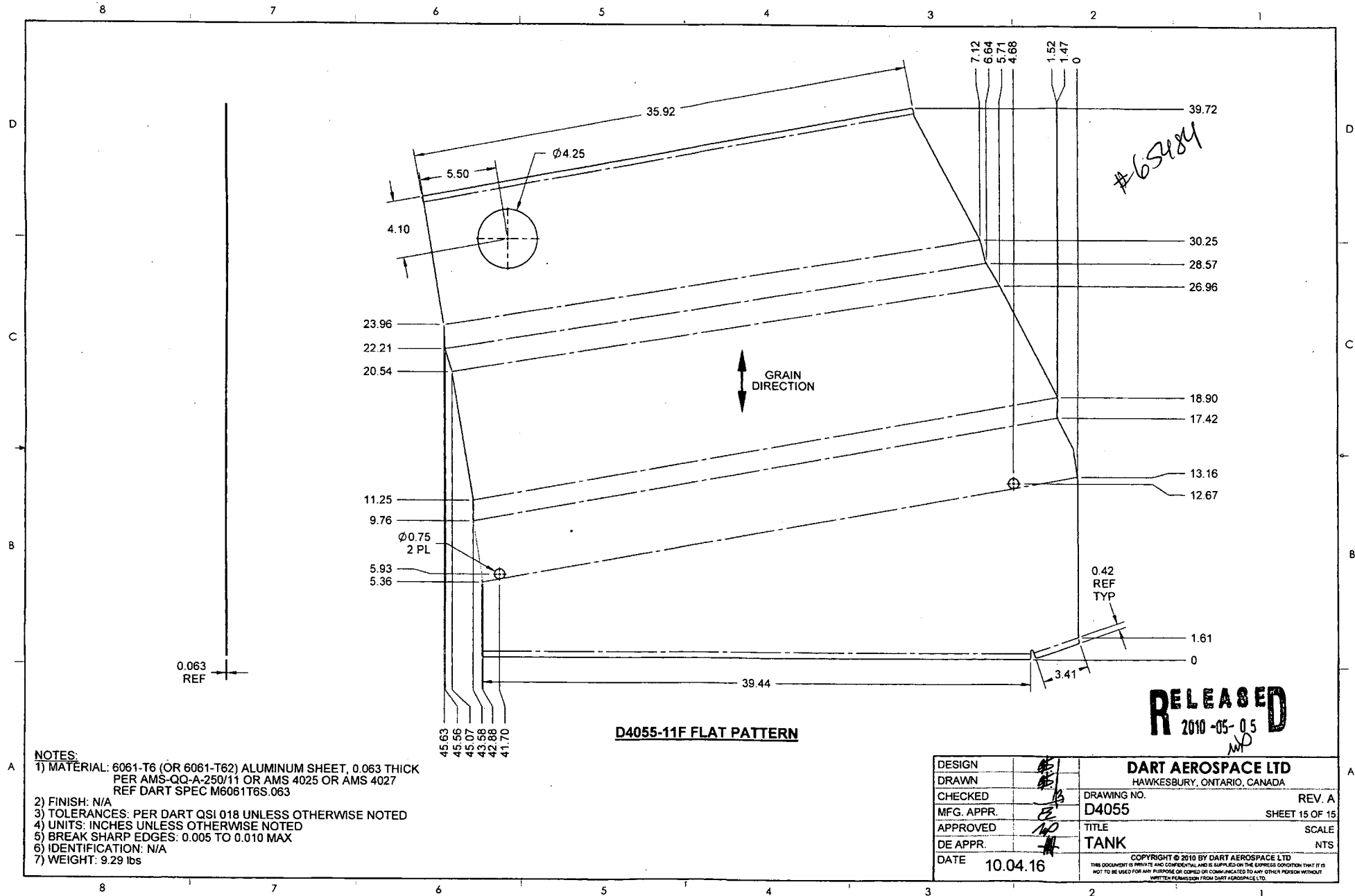
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.29 lbs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries